

5/17

DART AEROSPACE LTD	Work Order:	22814
Description: Head Rest	Part Number:	D3303-041
Dwg: D3303 Rev. A	Qty:	96
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler	KD	05/03/08	96																
2	GA	Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L or 8046 adhesive Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3303-043</td><td>Bracket Assembly</td><td>B21624B</td></tr><tr><td>1</td><td>D3305-1</td><td>Foam</td><td>B21626</td></tr><tr><td colspan="2">A/R 3M 1300/1300L or 8046 Adhesive</td><td></td><td>M17062</td></tr></table> Identify as D3303-041	Qty	Part Number	Description	Batch	1	D3303-043	Bracket Assembly	B21624B	1	D3305-1	Foam	B21626	A/R 3M 1300/1300L or 8046 Adhesive			M17062	2	05-05-31	6
Qty	Part Number	Description	Batch																		
1	D3303-043	Bracket Assembly	B21624B																		
1	D3305-1	Foam	B21626																		
A/R 3M 1300/1300L or 8046 Adhesive			M17062																		
3	GA	Cover Head Rest with D3306-041 as per Dwg D3303 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3306-041</td><td>Cover Assembly</td><td>B21627</td></tr></table>	Qty	Part Number	Description	Batch	1	D3306-041	Cover Assembly	B21627	2	05-05-31	6								
Qty	Part Number	Description	Batch																		
1	D3306-041	Cover Assembly	B21627																		
4	QC5	Inspect work to Step 3	U	05-06-01	6																
5	ST	Identify parts with batch number and part number, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a fine point permanent marker as per Dwg D3304 and Stock	ml	05-06-01	6																
6	AC	Cost / part: 140.46	545	05-06-03	6																
7	DC	Close W/O 141.56 Inspect Level 21	JH	05.06.07	6																

Rev	Date	Change	Revised By	Approved
A	04.09.07	New Issue	KJ/JLM	
B	04.10.05	Revised Step 5 with headrest identification	KJ/JLM	

RELEASED
11/21/10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

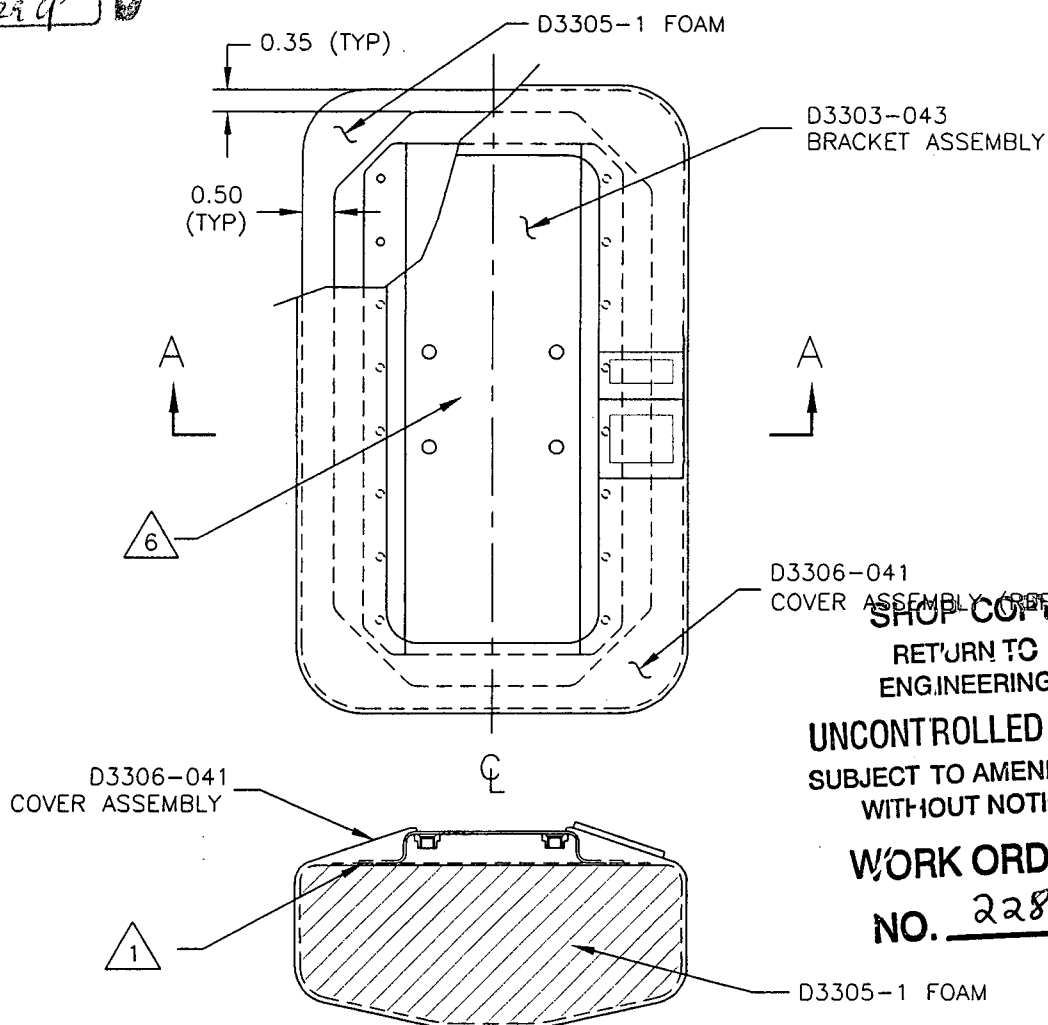
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:3
A	04.08.18	NEW ISSUE	

RELEASED
04.09.28 CP



SECTION A-A

D3303-041 HEAD REST

D3303-041 NOTES:

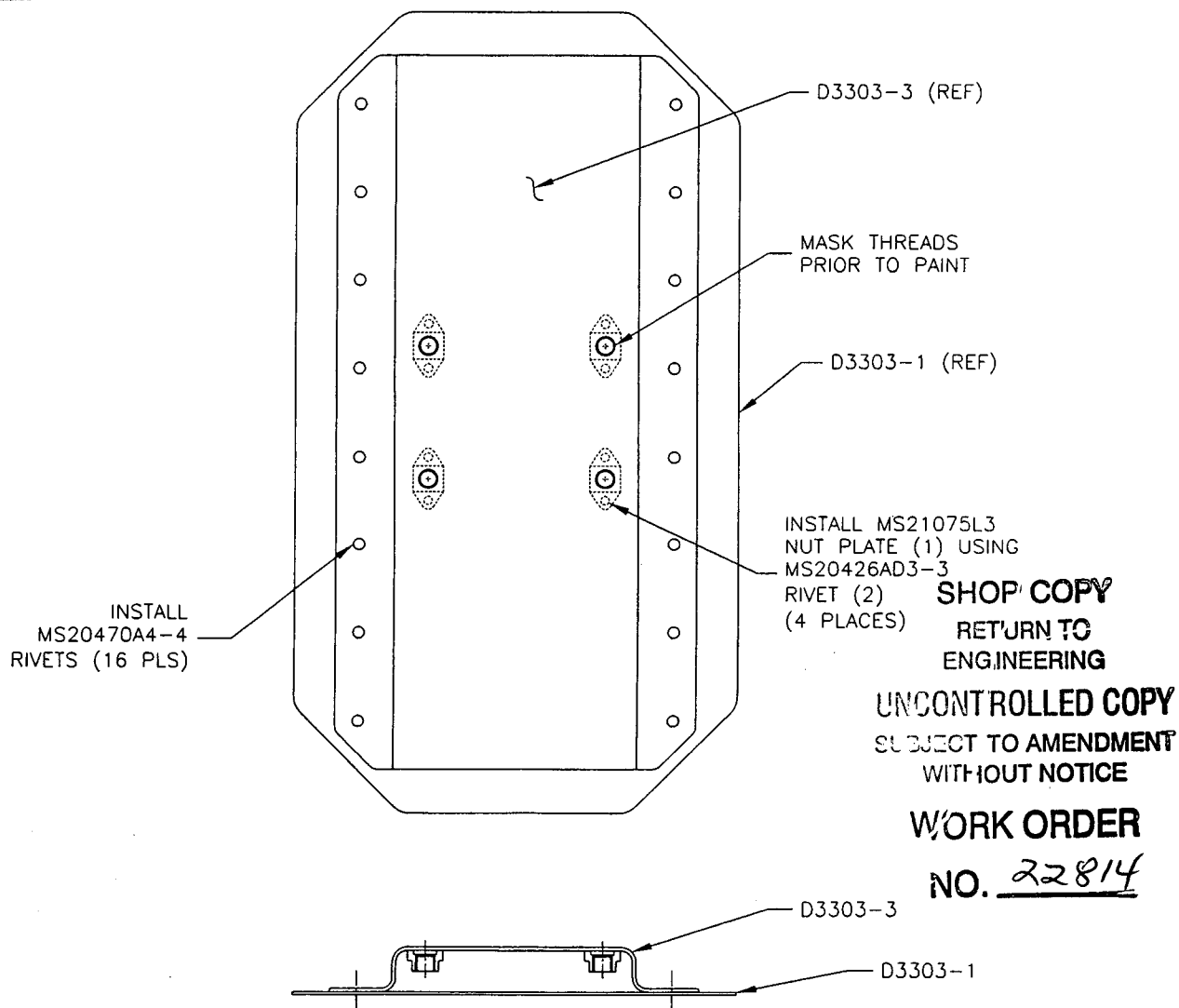
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT
ELIGIBILITY SEE PDA04-11"

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WORK ORDER
NO. 22814



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DATE 04.08.18		TITLE HEAD REST	SCALE 1:1

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D3303-043 BRACKET ASSEMBLY

D3303-043 NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

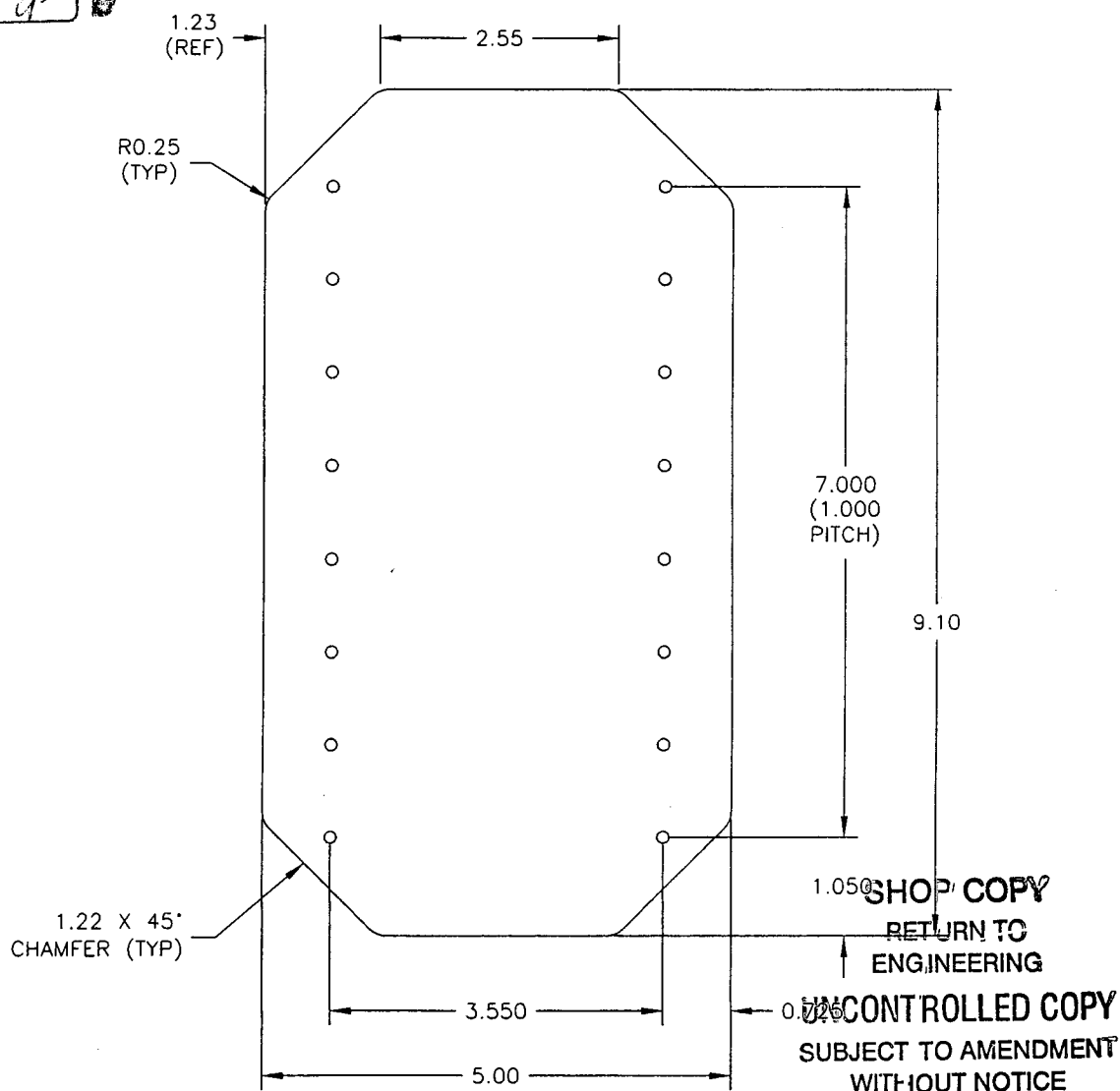
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 3 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

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NO. 22814

D3303-1 PLATE

D3303-1 NOTES:

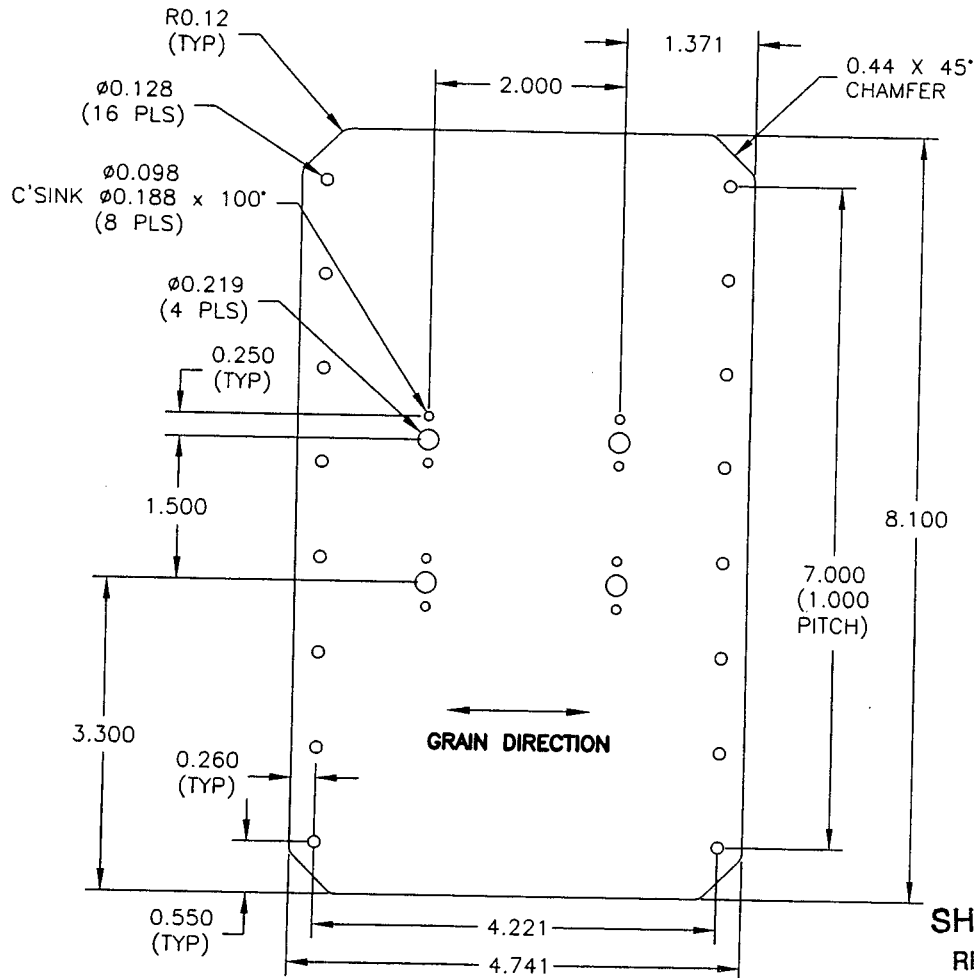
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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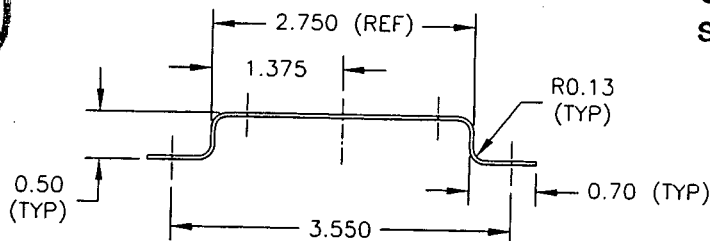
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3303	REV. A SHEET 4 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2



D3303-3 FLAT PATTERN



D3303-3 BRACKET
BEND DETAIL

D3303-3 NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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WORK ORDER
NO. 22814

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 23, 2005
07:09 am

Work Order No : 0022814
Project Name : D3303-041
Project For : WK517
Work Order Type : Main
Main WO Number :
House Part Number : D3303-041
Description : Head Rest
Manufactured : Yes
Amount Req'd : ~~0~~
Amount Done : 0
Start Date : 04-30-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00